

Work Order ID 134697

Wednesday, July 15, 2015 12:00:41 PM

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 7/15/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/15/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: JUL 15 2015 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100
100
 Mori Seiki
 Mori Seiki CNC Lathe Large
 MORI SEIKI CNC LATHE LARGE
 Memo
 Turn as per Folio FA599 Rev: 01 & Dwg D3391 Rev: I
 ensure steady rest is turning true
 ****REMOVE STEADY REST AND MACHINIG MARKS****

110
110
 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo

SCRAP

1 Ø
mm
15/07/28
1 Ø
mm
15/07/29

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

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N9000401 00

Stop *NS2*

Reference:

Stop ***NR2***

DAS
18
9-89

4.27)

0.00

Memo

Quality Control

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
180									
Skidtubes	Memo	0.02							
Skidtubes	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391 (Holes marked "A" Only.)								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig. *****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.297" and c'bore as per dwg D3391								
	6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.								
	7-Deburr								
	8- Scribe batch # on fwd end								

all holes
were open

DP 15-9-2

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.01							
210 *210* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00							

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Required Date: 7/15/2015 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start *NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
235 *235* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo AND REALODINE AS PER PAR09-043	0.00 0.01							
240 *240* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00							
250 *250* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

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Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

260

0.00

260

HandFinishing

HandFinish

Memo

0.01

Hand Finishing

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/ R Sikaflex-241/-291 _____

Sikaflex expiry date: _____

3- INSTALL WEARPLATES AS PER DWG

270

0.00

270

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

280

0.00

280

Identify as per dwg & Stock Location: _____

Packaging

Memo

0.01

Packaging

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Required Date: 7/15/2015 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start *NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

290

QC21- Final Inspection - Work Order Release

0.00

290

QC

Memo

0.00

Quality Control

Ø 2m 16/09/30

Picklist Print

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Work Order ID: 134697

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	11.0000	1	1			

D4095-047

Wearpad Aft

Location	Loc Qty	Loc Code
FP001	11	
116100	7	
133502	4	

D4095-049

Manufactured No

260

Each

33.0000

1

1

D4095-049

Wearpad Aft

Location	Loc Qty	Loc Code
FP001	33	
126331	33	

D6014-090

Manufactured No

100

Each

27.0000

1

1

D6014-090

ALUMINUM EXTRUSION

Location	Loc Qty	Loc Code
LG003	27	
79742	1	
86063	26	

1 mm L 15/27/23

Picklist Print

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Work Order ID: 134697

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

16.0000

4

4

D3670-4-200

Bushing

Location

Loc Qty

Loc Code

FG

10

87709

10

LG002

6

132777

6

D2646

Manufactured No

270

Each

62.0000

1

1

D2646

Aft Cap

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

58

103306

1

114495

1

127924

6

128761

2

132325

16

132326

32

Picklist Print

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Work Order ID: 134697

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

578.0000

2

2

D3672-1

Washer, Phenolic

Location

Loc Qty

Loc Code

FG

10

85222

10

FP001

138

113581

138

ST055

430

112218

72

120116

3

127322

355

ALS4-1032-130

AELS4-1032-130 Purchased

No

260

Each

1,213.000

14

14

AI S4-1032-130

Rivnut

Location

Loc Qty

Loc Code

st549

1213

M132317

1213

ALS4-1032-225

AELS8-1032-225 Purchased

No

270

Each

1,095.000

8

8

AI S4-1032-225

Rivnut

Location

Loc Qty

Loc Code

FG

120

M127028

120

FP001

484

M131582

484

st549

491

M131582

491

Picklist Print

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Work Order ID: 134697

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

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D3391-025

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

1,427.000

6

6

AN3C4A

Bolt

Location

Loc Qty

Loc Code

FG

20

122814

20

FP001

907

M132551

907

ST350

500

M132317

500

AN3C5A

Purchased

No

270

Each

501.0000

4

4

AN3C5A

Bolt

Location

Loc Qty

Loc Code

FG

5

122800

5

ST

56

121708

56

ST338a

440

M131803

40

M132640

400

Picklist Print

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Work Order ID: 134697

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

270

Each

4,223.000

10

10

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

257

m131618

257

ST271

1826

m129390

72

m132262

1754

DART AEROSPACE LTD		Work Order: 134697
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: I	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

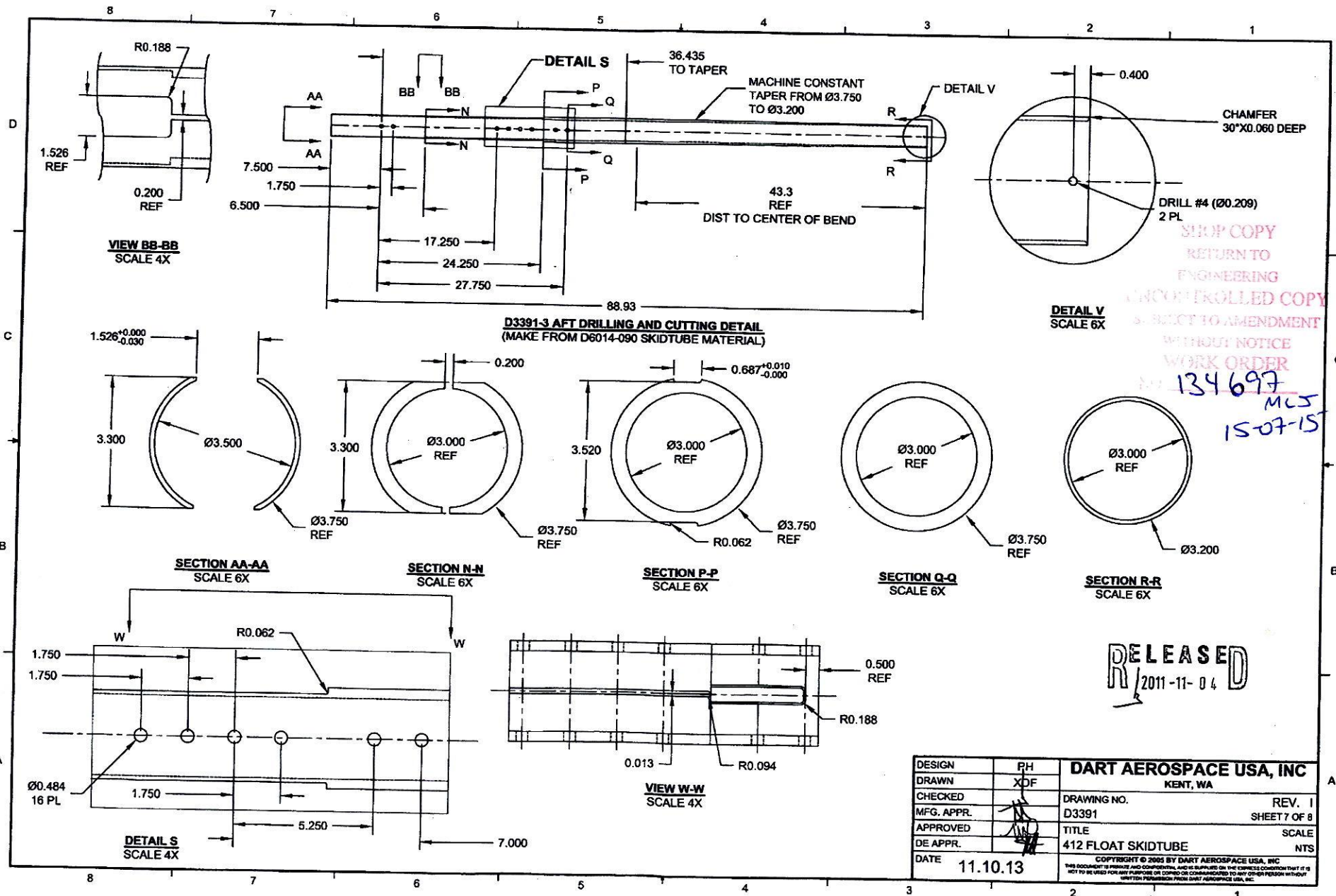
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	-		tape	LG-11
3.500	+/-0.010	3.501	-		vern	LWC-08
Ø3.200	+/-0.010	3.199	-			
Ø3.750	+/-0.010	3.750	-			
30° x 0.060 chamfer	+/-0.010	30° x 0.060	-			
88.93	+/-0.030	88.935	-		tape	LG-11

Measured by: M. L.	Date: 15/07/28
Audited by: 9	Date: 15/07/30

HAAS Section						
1.526	+0.000/-0.030	1.514	✓		SLO8	Vern
7.500	+/-0.010	7.497	✓		SLO1	Tape
27.750	+/-0.010	27.750	✓		"	
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
3.300	+/-0.010	3.301	✓		SLOP	
0.200	+/-0.010	.201	✓			
3.520	+/-0.010	3.522	✓			
0.687	+0.010/-0.000	.688	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.485	✓			

Measured by: 20	Date:
9-89	15-08-31
Audited by: DAS	Date: 15/08/31
14	

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	



DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PREPARED AND CONTAINS INFORMATION OF THE COMPANY AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

